Work Orde	er ID 98996 9:48:15 AM			*989	96*						Page 1	
Revision 1D:	D3255-041	1.5 144		Accept	*N900	040	100)* s	etup Star	1.7	S1*	
Item Name:	Access Panel Assembly	•							Stop	, *N	S2*	
	4/01/13 Start Qty		*2*		Cust Item I	D:						
Required Date:	4/01/13 Reg'd Qt	y: 2.00	*2* //	r 5÷	Customer:			1				
Reference:			· -				_	'n	un Star	t *NI	D1*	
Approvais:	Process Plan:	್ರ Date	: 13 <u>-04</u> -c	Tooling:	 Da	ate:			Stop	, 1/1	KI	
	QC:	Date	:	SPC (Y/N):	Da	ate:			5.51	*N	R2*	
Sequence ID/ Work Center II	Operation D Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	٢
Draw Nbr	Revision Nbr			· 	† ———							
D3255	Rev B										13-0	18
100			,	0.00		-	. .	Λ				1
100	Large Fab							1_				
Large Fab		Memo I-Weld as per Dwe D Batch: <mark>M I ユスオ</mark> ケ	3255 ***purge 2-Grind	0.00 weld***A/R SS ROD Welds Flush								
110	QC10- lnspe	ct visual per QSI004-	ground welds	0.00	•			•			DAS	
*11 ∩ *		.,		0.00	•				13-08	13	045 99	
Quality Control		Memo		,5.70							•	
120	QC5- Inspec	t part completeness to	step on W/O	0.00							(5 1)	
120		Memo		0.00				(3)	13-08	らら	(0.0 (0.0)	

Quality Control

NCR: Y	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
													QA Closed:	Date	2:	
Work Orde	er:						DISPOSITION	•			AGAINST D	EF	PARTMENT	PROCESS		
	-	-					Rework]	Skid-tube Crosstube					Water Jet	\Box	Engineering
Part N	ю.						Scrap							d. Eng. Coor.	ᅬ	Quality
							Use-as-is]]	Thermoforming Finishing Large Fab Composite				Rec/Store/Packaging			Other
NCR N	۱٥.						Work Order Update]		Large Fab			Supplier			
Root Desc				crip	otion of work order update		Initial Action		ion	n Sign 8		•				
Cause		Date	Step	Qty		С	r Non-conformance	Ch	ief Eng	Descr	iption	_	Date	Verification	_	QC Inspector
Doc/Data												-				
quip/Tooling	_						•						!	-		
Operator															-	
Material	_															
Setup	_															
Other	_													;		
rocess	4							-								
Supplier	\dashv															
Fraining	_			•						•		1		,		•
Jnapproved	·				<u> </u>			<u> </u>	T CATE	CORV			<u> </u>	<u> </u>		
l mandi:		`~~					General	AUL	TCATE	JONT				<u> </u>		
Landi:	$\overline{}$		•				Bend	Γ-	Grain		Γ	-	Ovalized	Г		Pressure/Forced
	-	Bending Centre No	st Concer	atric to	0/5		BOM/Route	-	Hardwa	ro	F		Over/Under	tolerance		Temperature/Cure
ا اند			A CONCE	iti ic to	0/3	_	Broken/Damaged	-	-	on Incomplete	F	-	Part Incorre		_	Weld
Ì				Burrs		1 '	ions Incomplete/l	Jnclear -	-	Part Lost/M	<u>+</u>		Wrong Stock Pulled			
	H			Contamination		Mainte	•	,	_	Part Moved		٠,	1 - 0			
				Countersink		Mislabe		<u> </u>		Positioned V	Vrong					
İ	Inspection Strip in Tube Cut Too Short				Misread			Power Loss/Surge			Other					
	Ripples in Bend Drill Holes				Offset	gener.	· L			- L						
Torque Waves in Extrusion Drawing			1	-	Calibration				· · · · · · · · · · · · · · · · · · ·							
Turning Sequence				Finish	\vdash	Out of S	equence					_				

Outșide Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

D3255A/R 736

Batch: /223 Y

DOW CORNING ADHESIVE

NCR:	Yes	/	No

DQA: _____ Date: ____

NCR: Y	es / No				WORK ORDER NON-0	CONFOR	MANCE / UP	DATE	QA Closed:	Date	:
Mark Orda					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Work Orde					Rework Scrap]	Skid-tube Machining	Pro	Water Jet d. Eng. Coor.	Engineering Quality	
Use-as-is Thermoforming					~ —	Small Fab Finishing Composite	-	re/Packaging Supplier	Other		
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Initial Chief En	ŀ	ction cription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training											
Unapproved		<u></u>				AULT CAT	EGORY		<u> </u>		
Landir	ng Gear	-			General						
	Bending Centre N Cracks Crushed/ Cuffs	'Crimped		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink	Instru	vare ction Incomplete ctions Incomplete, tenance	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned	issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
├ ─ ┤ `` ̄ ̄`` ̄			Cut Too Short	Misre			Power Loss,		Other		
		Drill Holes	Offse				- L				
1	Torque V		Extrusio	n	Drawing	Out o	f Calibration				
ľ	Turning 9	Sequence	!		Finish	Out o	f Sequence	-			
	Wave/Tw	vist in Tu	be		Folio	Outsi	de Dimensions				

March-28-13 10:48:15 AM *N900040100* D3255-041 Accept Item ID: Setup Start Revision ID: Access Panel Assembly Item Name: Start Qty: 2.00 Start Date: 4/01/13 Cust Item ID: Req'd Qty: 2.00 Required Date: 4/01/13 Customer: Reference: Run Process Plan: Date: Tooling: Approvals: Stop Date: SPC (Y/N): Date: __ Sequence 1D/ Set Up/ Tool ID Tool # Plan Accept Reject Reject Operation Insp. Run Hours DAS Work Center ID Description Qty Number Stamp Code Qty QC5- Inspect part completeness to step on W/O 0.00 160 27 *160* 9-89 QC 0.00 Memo Quality Control Identify as per dwg & Stock Location 170 *170* 0.00 Packaging Memo Packaging 180 QC21- Final Inspection - Work Order Release 0.00*120* 0.00 QC Memo Quality Control

plesof

NCR: Y	R: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:											
Work Orde	r:				DISPOSITION	_		AGAINST	DEPA		PROCESS	
Part No.				Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing		Prod. Eng. Coo			Engineering Quality Other	
NCR N	0	····	,		Work Order Update] "		Large Fab Composite			Supplier	
Root				Descri	iption of work order update	Initia	al	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief I	Eng	Description		Date	Verification	QC Inspector
oc/Data quip/Tooling												
perator							- 1					
/laterial	_		1			S	.					
etup	\dashv	ł				-						
other Process	┥											
upplier	⊢						.					
raining	=					•						
inapproved												
		 			F	AULT C	ATEG	GORY				
Landin	ng Gear		,		General							_
ſ	Bending	3			Bend	Gra	ain			valized		Pressure/Forced
	Centre	Not Conce	ntric to (o/s	BOM/Route	Har	dwar	re	—		tolerance	Temperature/Cure
[Cracks				Broken/Damaged	Ins	pectio	on Incomplete	\vdash	irt Incorre		Weld -
	Crushed	I/Crimped		_	Burrs	-		ons Incomplete/Unclear	-	irt Lost/M	issing [Wrong Stock Pulled
Ĺ	Cuffs				Contamination	-		nance	\vdash	rt Moved		
Ļ	Heat Treat Count		Countersink	<u> </u>	slabel		-	sitioned V	· .	¬		
			Cut Too Short	$\boldsymbol{\vdash}$	sread		∐P(ower Loss/	'Surge [Other		
ļ	Ripples			L	Drill Holes	Offset						
Torque Waves in Extrusion Drawing			⊣	Out of Calibration					<u> </u>			
Turning Sequence			Finish	[]Qu	Out of Sequence							

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

Picklist Print

March-28-13 10:48:14 AM

Work Order ID:

98996

Parent Item:

D3255-041

Parent Item Name:

Access Panel Assembly

Start Date: 4/01/13

· Required Date: 4/01/13

Start Qty: 2.00

Required Qty: 2.00

D3255-1 Manufactured No 100 Each 2.0000 I 2 Location Paper Loc Otv Loc Code	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq 1D	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
Manufactured No		- 		No			100	Each	2,0000	- 1	2			120
3255-3 Manufactured No 150 Each 4.0000 1 2 Location Loc Otv Loc Code	mel				W/1002 9	•	Loc Oty 2	<u>L</u>	oc Code		2			13-0
WA001 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2		·	Manufactured	No	,,,		150	Each	4.0000	1	2		≠ (*	13-0
75969 2 WA002 98272 2 83201 2 Manufactured No 100 Each 4.0000 1 2 FF 13-0 Location					Location	•	Loc Oty	Le	oc Code					
Manufactured No 100 Each 4,0000 2 FF 13-0							2							
Location Loc Oty Loc Code GA 98928 4 72118 1		·			waaaz 9	8272	2 2 2				2			
GA 98928 4			Manufactured	No			100	Each	4.0000	1	2	FF	13-	වල්- 2
75083						9928	<u>Loc Oty</u> 4	<u>L</u>	oc Code					
96137 2					75	083	1							
					96	137	2							

Page 1

NCR: Ye	R: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE										
									QA Closed:	Date	
Work Ordei	r:				DISPOSITION			AGAINST DE	PARTMENT		
Part No	-				Rework Scrap Use-as-is Work Order Update	rap Machining Small Fab Prod. Eng. Coor. Qu is-is Thermoforming Finishing Rec/Store/Packaging O					
Root Desc				Descr	 iption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	}	or Non-conformance	Chief Eng		ription	Date	Verification	QC Inspector
Doc/Data			,					<u> </u>			
quip/Tooling	_										
Operator											
Material											
Setup			i :								
Other]				1			}		
rocess						ļ				l !	
Supplier				-							
Fraining											
Jnapproved		1	L		· ·· · · · · · · · · · · · · · · · · ·				1		1
		-				AULT CAT	EGORY			-	
Landin	_			_	General				٠	Г	Pressure/Forced
-	Bending				Bend Bend	Grain		<u> </u>	Ovalized	+ alasansa	Temperature/Cure
·	Centre No	ot Concer	ntric to	O/S -	BOM/Route	Hardw		\vdash	Over/Under Part Incorre		Weld
-	Cracks		Broken/Damaged	—	tion Incomplete ctions Incomplete/	Lindon	Part Lost/M		Wrong Stock Pulled		
-	Crushed/Crimped.			Burrs Contamination	\vdash	ctions incomplete/ tenance	Unclear –	Part Moved	issuig [
-	Cuffs			Countersink	Mislat			⊣ ````	Mrong		
			╡	Misre			Positioned Wrong Power Loss/Surge		Other		
Inspection Strip in Tube Cut Too Short			Drill Holes	Offset		L	J. 54461 1033/	~~'6\ _			
—			Drawing	\vdash	f Calibration				· · · · · · · · · · · · · · · · · · ·		
				''	Finish		Out of Sequence				

Outside Dimensions

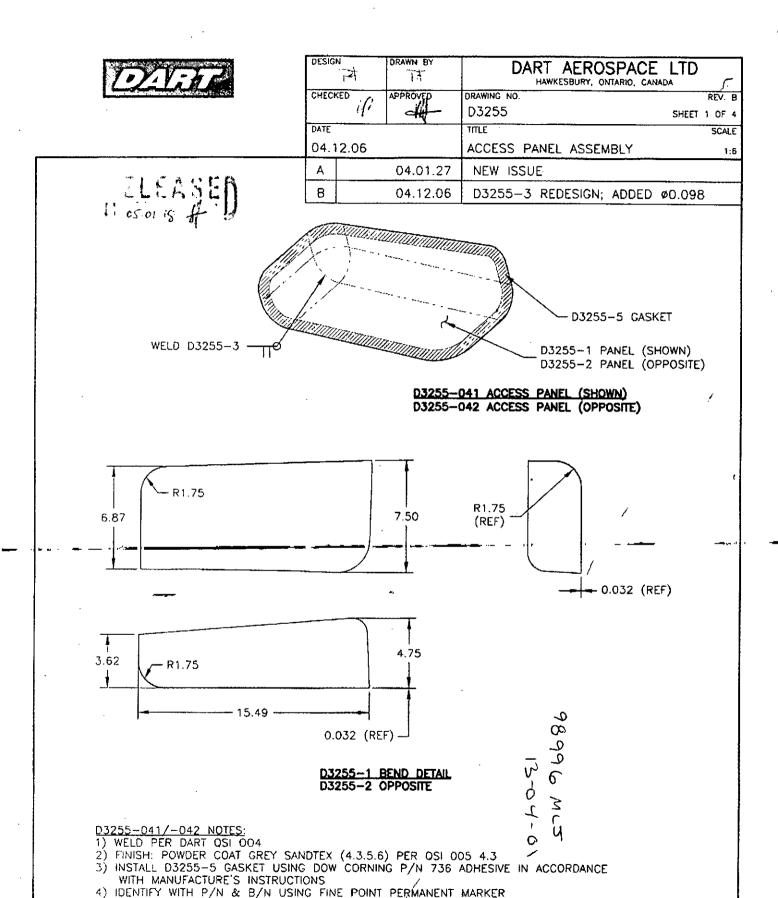
DQA: ____

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



Copyright © 2004 by DART AEROSPACE LTD

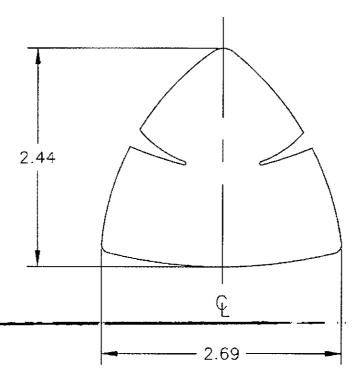
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

	•	



DESIGN T.F	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. B
41	-	D3255	SHEET 2 OF 4
DATE	1	TITLE	SCALE
04.12.06		TITLE	1:1

ELEASED



D3255-3 CAP FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

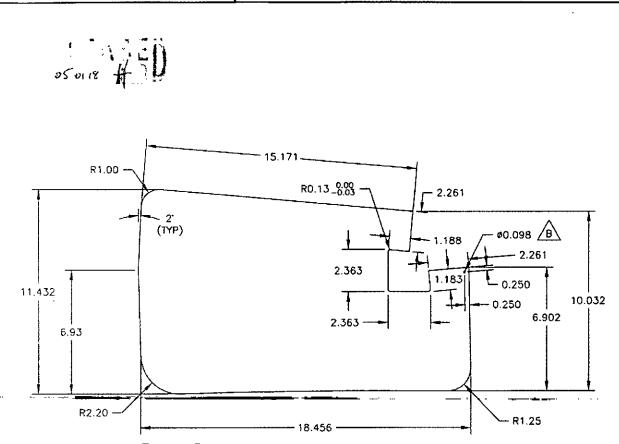
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

.



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
CHECKED (APPROVED	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

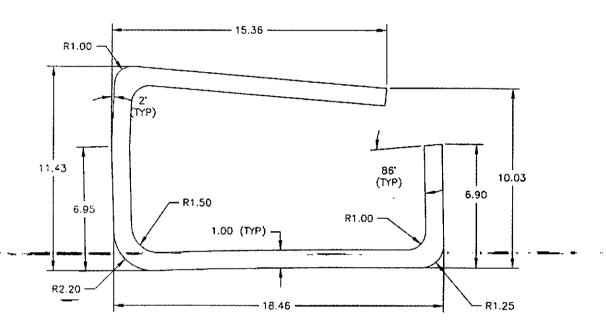
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

•		<u> </u>	•••		=		
							•
		•					
		-					
• .	.5						
-							·
						-	



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED	DRAWING NO.	REV. B
4'	70	D3255	SHEET 4 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5



D3255-5 GASKET

- D3255-5 NOTES:

 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

• . • •